

Date: Wednesday, 03/09/2008 3:28:53 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SQUARE TUBE
Job Number	: 41789		
Estimate Number	: 13425		
P.O. Number	:	Part Number	: PB6743001203
This Issue	: 03/09/2008 S.O. No. :	Drawing Number	: B6743001 P.17
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 40594	Material	:
Written By	:	Due Date	: 10/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>mf 08-09-03</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6TS1000W065

6061T6 SQ TUBE 1.00 x 1.00 X 0.065w



Comment: Qty.: 1.6844 f(s)/Unit Total: 16.8441 f(s)

6061T6 SQ TUBE 1.00 X 0.065

batch: m109057

08.09.22 10

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- make a 0.050" chamfer on both ends of tube

3- deburr

08.09.22 10
08.09.22 10
08.09.22 10

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/22 (44)

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes as per dwg

2- make a 0.050" chamfer (100 degree) on both side of the 2 holes

3- deburr

mf 08/09/23

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/24 (P10)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 41789

Part Number: PB6743001203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001227

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

batch: 3 40273 = 16

3 24006 = 4

08-09-24 10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

08-09-24 10

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

08-09-24 10

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 08-09-24 10

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/25

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: B1

8/9/25

10x 54

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion

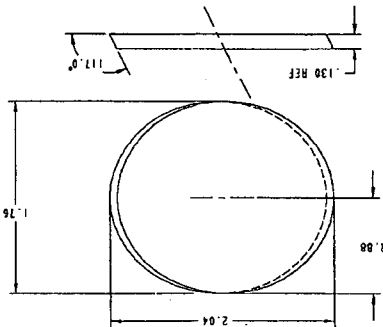


MF 08-09-26

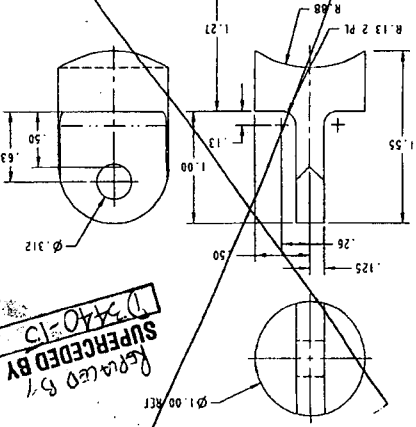
ORIGINAL

PREMIER AVIATION, INC.
3000 Aviation Parkway, Grand Prairie, Texas 75050
DLSUB B67-43001
SCALE 1:100

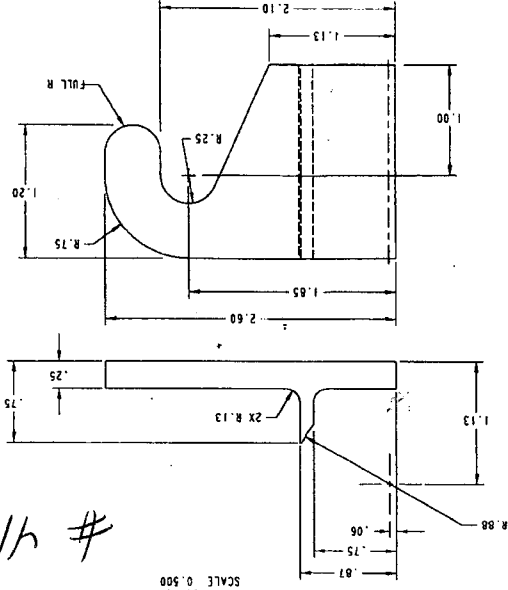
②
-199 OUTER TUBE END CAP
MATERIAL: 1.25 THK. 6061-T6
SCALE 2:000



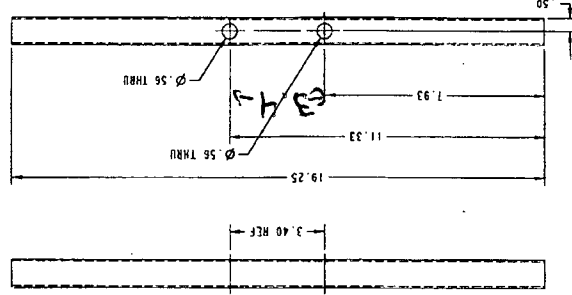
①
-215 CONTOURED MALE EYE
MATERIAL: 1.00 RND. 6061-T6
SCALE 2:000



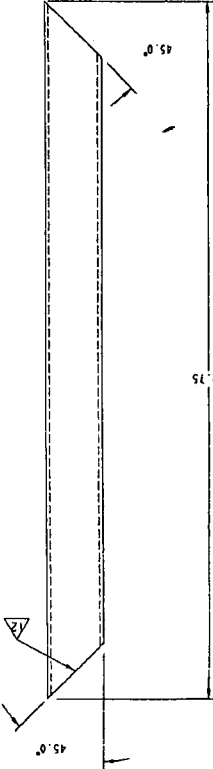
②
-213 FLANGED HOOK
MATERIAL: 6061-T6 00-A-200/8
SCALE 2:000



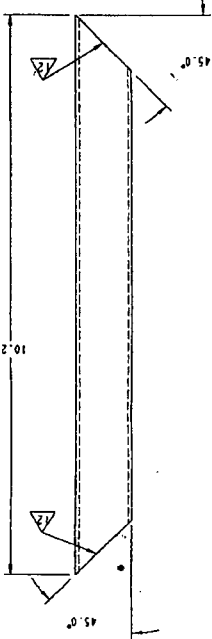
②
-203 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL 6061-T6
SCALE 0:500



②
-211 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL 6061-T6
SCALE 1:000



②
-209 SQUARE TUBE
MATERIAL: 1.00 SQ X .065 WALL 6061-T6
SCALE 1:000



RELEASED
#06 01 20

REPLACED BY
D3440-13